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RBE332A94-3400-03-9
Job Sheet 191120



Part No: RBE332A94-3400-03-9

Job Qty: 2 pcs

Part Name: Sight Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/21/19

Job Tracking No:

Due Date: 3/22/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE332A94-3400-03 Rev A IPP Rev. A 19.02.19 New issue DP Verify DD

Ship Via:



Bill of Materials

Dart Aerospace Ltd.
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Hawkesbury, ON K6A 1K7
CANADA
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Container No: S170155



Part: RBE332A94-3400-03-9

Job No: 191120

Serial No/Batch: S170155

Revision: A

Inspector:

Exp Date:

Instructions:

Date: 04/06/19

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	2 pcs	3/22/19		0.00	0.40	Small Fab - 1		MLC
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	2 pcs	3/22/19		0.00	0.00	QC 5 - 10		DAG 19 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
120	Packaging 3-1 - Stock - B4B	2 pcs	3/22/19		0.00	0.00	Packaging 3 - 1 - B4B		DAG 21 9-89 APR 08 2019
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
130	QC 21 - FG	2 pcs	3/22/19		0.00	0.00	QC 21 - FG - 21		DAG 21 9-89 APR 08 2019
							QC 21 - FG - 70		
							QC 21 - SA - 53		

Part Op 100 - Assemble as per DWG. See note 8.

Descriptions: 120 - The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG.

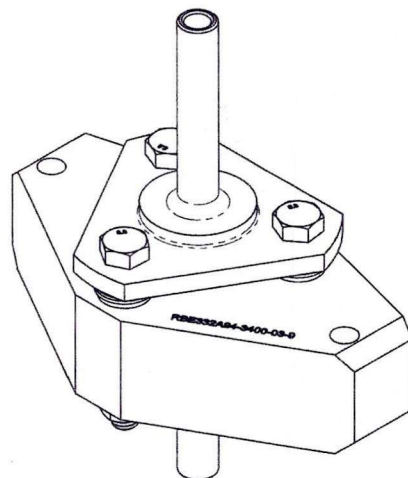
Job BOM

Part / Item	Component Name	Quantity	Operation	Container
65 90591A161	Hex Nut M8 x 1.25	6 Ea (3 ea)	100-Small Fab - 1	7 FM 138414-8
67 91166A270	Washer, M8	6 Ea (3 ea)	100-Small Fab - 1	12 12 70
70 91280A550	ZINC PLATED CLASS 8.8 STEEL HEX HEAD SCREW M8 X 1.25 mm X 60 mm LG.	6 (3 ea)	100-Small Fab - 1	5057240
58 96445K241	STEEL BELLEVILLE DISC SPRING 9.2 mm ID. X 18 mm OD. X 1 mm THK.	24 (12 ea)	100-Small Fab - 1	5157747
140B RBE332A94-3400-03-10 Block		2 pcs (1 ea)	100-Small Fab - 1	5163924
RBE332A94-3400-03-11 Support		2 pcs (1 ea)	100-Small Fab - 1	5165768 5160895

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	90591A161	6	84	0
	91166A270	6	161	0
	91280A550	6	0	0
	96445K241	24	0	0
	RBE332A94-3400-03-10	2	0	0
	RBE332A94-3400-03-11	2	0	0
Part Specifications				
Specifications could not be found.				

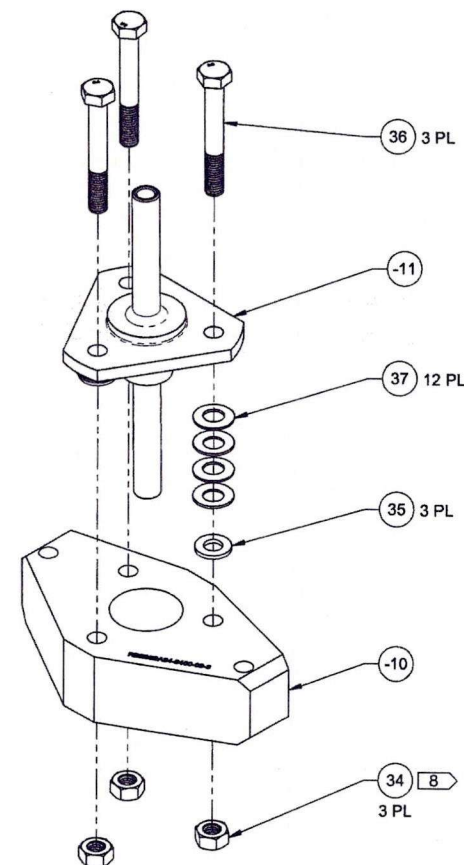
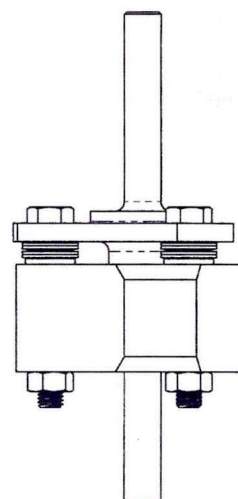
Plex 2/21/19 1:12 PM Dart.lajeunesse.marie

ITEM #	QTY	PART #	PART TITLE
-10	1	RBE332A94-3400-03-10	BLOCK
-11	1	RBE332A94-3400-03-11	SUPPORT
34	3	McMaster#90591A161 OR EQUIV.	ZINC PLATED CLASS 8 STEEL HEX NUT M8 X 1.25 mm X 6.5 mm HT.
35	3	McMaster#91166A270 OR EQUIV.	ZINC PLATED STEEL WASHER 8.4 mm ID. X 16 mm OD. X 1.4 mm-1.8 mm THK.
36	3	McMaster#91280A550 OR EQUIV.	ZINC PLATED CLASS 8.8 STEEL HEX HEAD SCREW M8 X 1.25 mm X 60 mm LG.
37	12	McMaster#96445K241 OR EQUIV.	STEEL BELLEVILLE DISC SPRING 9.2 mm ID. X 18 mm OD. X 1 mm THK.



RBE332A94-3400-03-9 SIGHT SUPPORT

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NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) INSTALL ITEM 34 HAND TIGHT
- 9) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

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WITHOUT NOTICE
WORK ORDER

NO. 191120 MWS
19-02-21

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT	TOOL PART #	REV. A
CHECKED	MBB	RBE332A94-3400-03	SHEET 10 OF 28
MFG. APPR.	DP	TITLE	SCALE
APPROVED	WY	T/R DRIVE ALIGNMENT INSPECTION	NTS
DATE 2/14/2019		COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					